

Work Order ID 69544

Wednesday, May 11, 2011 3:15:44 PM



Page 1

Item ID:	D3651-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bottom Flange					
Start Date:	5/11/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	5/16/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	5-11-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							FB11-5-19
FLOW CNC Waterjet	1-Cut as per Dwg D3651								
304 .018	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
			SN 1165119						⑤
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							FB11-5-19
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control			51165119						⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3651-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Flange

Start Date: 5/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Brake NC

Form as per dwg
NC BRAKE

0.00

Memo

0.00

Ss 11/05/25

(5)

Brake NC

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/07/30

(25)

Quality Control

180



Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

W/O 70065

Ss 11/05/30

(5)

Packaging

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Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30

11-05-30
⑤

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Picklist Print

Wednesday, May 11, 2011 3:15:51 PM

Page 1

Work Order ID: 69544

Parent Item: D3651-7

Parent Item Name: Bottom Flange




Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			100	sf	15.0000	0.3	1.263158			



1315-19

Location

Loc Qty

Loc Code

MAT020

15

109398

3

112885

12

109398

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DART AEROSPACE LTD		Work Order:	<i>69544</i>
Description: Bottom Flange		Part Number:	D3651-7
Inspection Dwg: D3651 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	<i>.100</i>	<i>x</i>		<i>V</i> <i>1362</i>	
Ø0.129	+0.005/-0.001	<i>.132</i>	<i>x</i>		<i>V</i>	
0.26	+/-0.030	<i>.264</i>	<i>x</i>		<i>V</i>	
0.500	+/-0.010	<i>.499</i>	<i>x</i>		<i>V</i>	
0.19	+/-0.030	<i>.190</i>	<i>x</i>		<i>V</i>	
0.450	+/-0.010	<i>.452</i>	<i>x</i>		<i>V</i>	
2.10	+/-0.030	<i>2.106</i>	<i>x</i>		<i>V</i>	
2.31	+/-0.030	<i>2.314</i>	<i>x</i>		<i>V</i>	
6.94	+/-0.030	<i>6.945</i>	<i>x</i>		<i>V</i>	
0.23	+/-0.030	<i>.226</i>	<i>x</i>		<i>V</i>	
3.09	+/-0.030	<i>3.093</i>	<i>x</i>		<i>V</i>	
0.29	+/-0.030	<i>.286</i>	<i>x</i>		<i>V</i>	
0.96	+/-0.030	<i>.964</i>	<i>x</i>		<i>V</i>	
0.24	+/-0.030	<i>.242</i>	<i>x</i>		<i>V</i>	

Measured by:	<i>B</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	<i>11-5-19</i>	Date:	<i>11/05/19</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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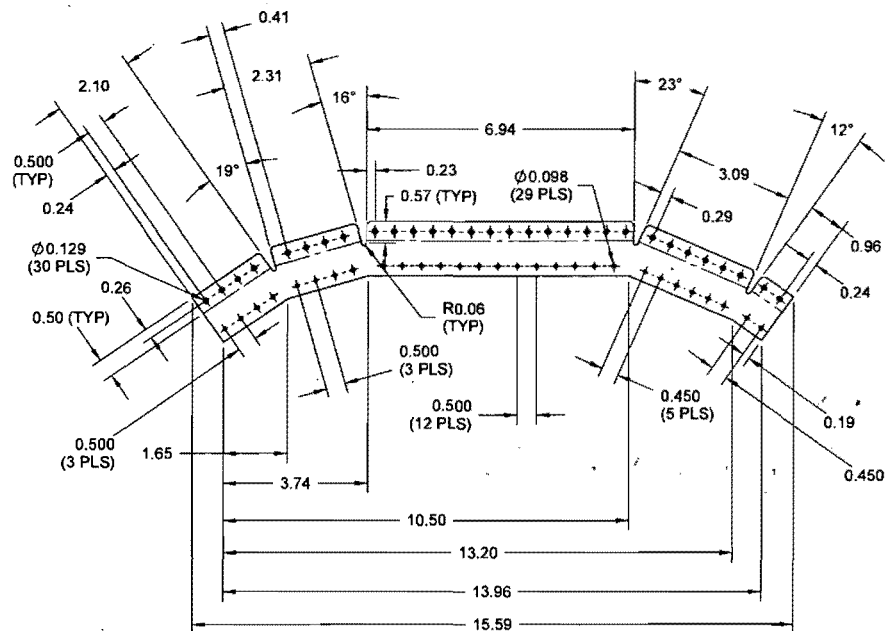
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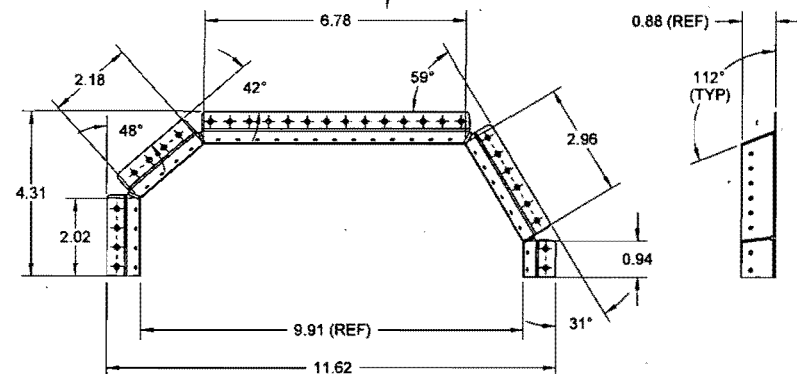
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 695414 11-054







D3651-7F FLAT PATTERN



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3651	REV. B
MFG. APPR.		SHEET 6 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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